

Work Order ID 72070

Tuesday, July 19, 2011 8:10:40 AM

Page 1

Item ID: D3641-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Cover

Start Date: 7/19/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-19 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3641

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3641

Dwg Rev: E

Prog Rev: C

2-Deburr if necessary

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

11 07 21 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




NOTE: Date & initial all entries

Tuesday, July 19, 2011 8:10:40 AM

Page 2

Item ID:	D3641-4	Accept		Setup	Start	
Revision ID:						
Item Name:	Cover				Stop	
Start Date:	7/19/2011	Start Qty:	8.00		Cust Item ID:	
Required Date:	7/26/2011	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				8			
Brake NC	Memo	0.00	SB 11/6/27						
Brake NC	Form as per Dwg D3641-4								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	✓ 11 07 27 (8)						
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00	3 0 11-7-27.						
Hand Finishing									

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Page 3

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Item ID: D3641-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 7/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8. 6 11/10/22

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

5/ 14/7/27

180

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/7/28

11/20/28

Dart Aerospace Ltd

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Picklist Print

Tuesday, July 19, 2011 8:10:46 AM

Page 1

Work Order ID: 72070

Parent Item: D3641-4

Parent Item Name: Cover





Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	105.0000	0.7851	6.611368			
 													

5052-H32 .032 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	105	
100470	2	
103321	2	
105998	3	
108462	5	
109478	6	
111448	2	
112664	16	
115638	12	
116657	27	
117798	30	

6.7 ~~7.7~~ 11/07/21

Dart Aerospace Ltd

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Dart Aerospace Ltd

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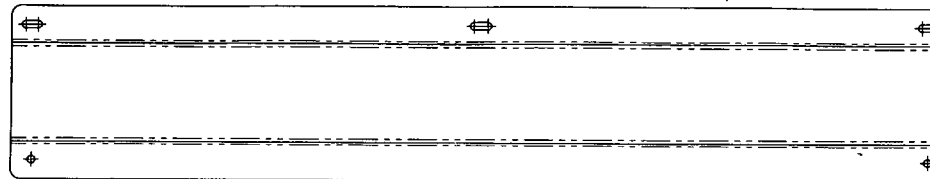
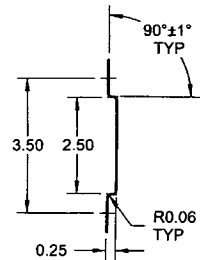
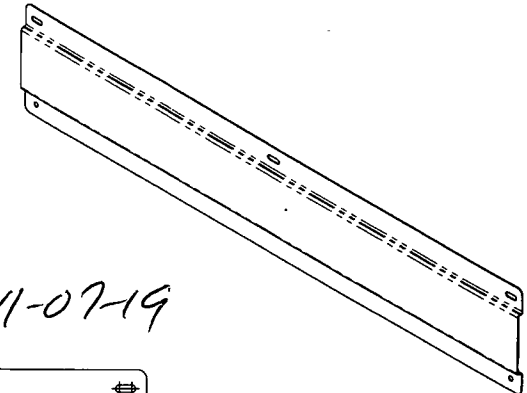
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 72070 PL 11-07-19



D3641-1 COVER
 (REPLACES GENEVA P/N G10606-3/-6)
 (MAKE FROM D3641-1F FLAT PATTERN)

RELEASED
 2009 -11- 18

NOTES:

- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

C	REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F/-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076	RF	09.10.02
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.02		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3641	REV. C
TITLE COVER	SHEET 1 OF 3
	SCALE NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

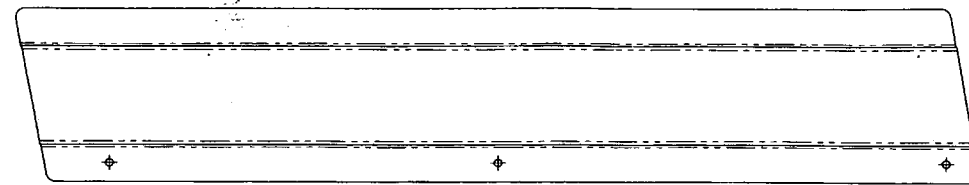
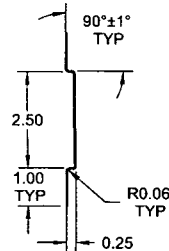
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

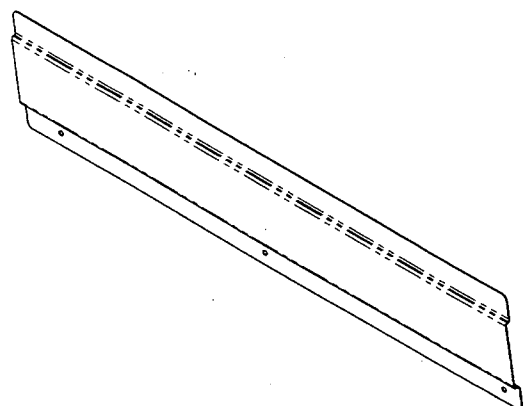
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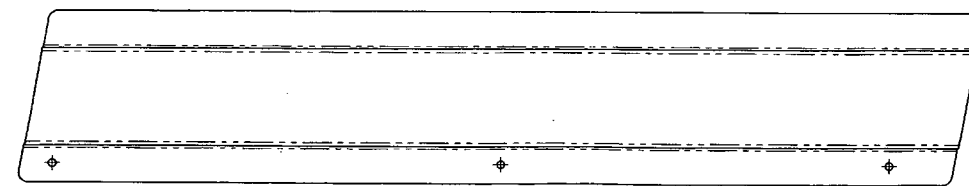
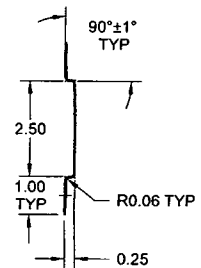
8 7 6 5 4 3 2 1



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
(MAKE FROM D3641-3F FLAT PATTERN)



D3641-3 COVER (SHOWN)
D3641-4 COVER (OPPOSITE)



D3641-4 COVER
(REPLACES GENEVA P/N G10606-4)
(MAKE FROM D3641-3F FLAT PATTERN)

72070

RELEASED
2009 -11- 10
MP

NOTES:

- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	09.10.02	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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